

# Work Order ID 65902

Thursday, January 27, 2011 8:42:37 AM

Page 1

Item ID: D3536-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 1/27/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536. 1-Dwg Rev: A 1-Prog Rev: A 1-2-  
Deburr if necessary

11-1-27

12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

11-1-27

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Sublot 27

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65902

Thursday, January 27, 2011 8:42:37 AM

Page 2

Item ID: D3536-13

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 1/27/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: FP

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/4/28 (2)

11/01/31 (2)

PL 11-01-28 (2)

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 27, 2011 8:42:33 AM

Page 1

Work Order ID: 65902

Parent Item: D3536-13

Parent Item Name: Gasket

Start Date: 1/27/2011

Required Date: 1/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	321.3220	0.8269	11.02533			

NEOPRENE SHEET 0.063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	321.322	
115500	74.522	
115916	246.8	

1311-1-27

115916

12

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	65902
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	x		T 1B01	
29.40	+/-0.030	29.40	x		T	
27.40	+/-0.030	27.40	4		T	
23.90	+/-0.030	23.90	4		T	
18.98	+/-0.030	18.98	4		T	
14.07	+/-0.030	14.07	X		T	
9.15	+/-0.030	9.15	4		T	
5.65	+/-0.030	5.65	x		T	
3.90	+/-0.030	3.90	4		T	
8.00	+/-0.030	8.00	x		T	
14.00	+/-0.030	14.00	x		T	
20.00	+/-0.030	20.00	x		T	
1.89	+/-0.030	1.888	2		V 1B02	
0.30	+/-0.030	.303	x		V	
0.30	+/-0.030	.303	2		V	
Ø0.19	+0.005/-0.001	193	x		V	

Measured by: 1B	Audited by: S	Prototype Approval:	N/A
Date: 11-1-07	Date: 11/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	EE

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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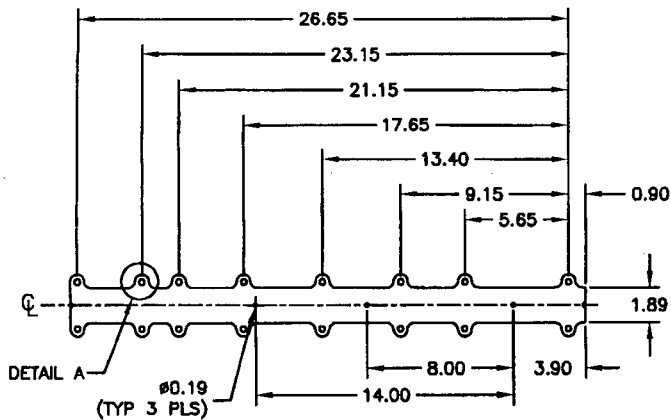
NOTE: Date & initial all entries



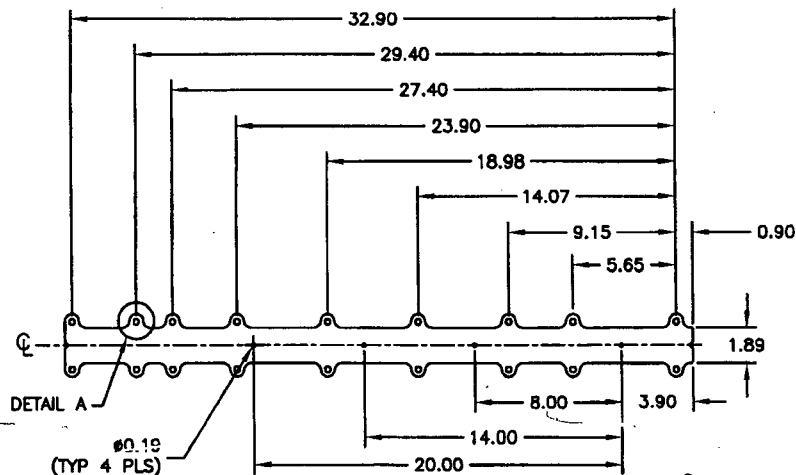
**DART**

RELEASED  
09-02-12-11

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



**D3536-11 GASKET**



**D3536-13 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

65903

W/O:		WORK ORDER CHANGES					
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